



Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200

**D119-646-243**  
**Job Sheet 180168**



Part No: D119-646-243

Job Qty: 1 ea

Part Name: AW119 Repl. Skidtube with Heavy Duty Wearplates, Float Compatible -Fits LH or RH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/29/18

Job Tracking No:

Due Date: 8/6/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG IIN-D119-646 REV D, D3905-045 REV E SHEETS 4,5, 7-14 IPP RevA: New issue DD verified by:EC  
IPP REVB 12.11.05 (DEOD3905-B-1)(ecn 12-675) DD verf:JLM IPP REV:C 13.03.20 per chg003 ECN13-534  
DD verf:JLM IPP REV:D 15.01.19 AS PER ECN-14-628 DD verf:JLM IPP REV:E 16.11.02 chg as per D3905  
revD(DEO) DD verf:JLM IPP REV:F 17.05.19 as per dwg D3905 rev.e DD verf:JFS

Ship Via:

### Bill of Materials

### Job Routing

| Op No | Operation          | Qty   | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off       |
|-------|--------------------|-------|------------|----------|-----------|---------|-----------------------|-----------|----------------|
|       |                    |       |            |          | Setup hrs | Run Hrs | Workcenter / Supplier | Lead Time |                |
| 90    | Start up Operation | 1 Ea  | 8/6/18     | 8/6/18   | 0.00      | 0.00    | Start Up Skidtubes-1  |           |                |
| 110   | Skidtubes          | 1 pcs | 8/6/18     | 8/6/18   | 0.00      | 2.07    | Skidtubes-1           |           |                |
| 120   | HandFinish         | 1 pcs | 8/6/18     | 8/6/18   | 0.00      | 1.05    | HandFinish1           |           | SA 18-07-09    |
| 130   | QC                 | 1 pcs | 8/6/18     | 8/6/18   | 0.00      | 0.00    | QC7-1                 |           | MLH            |
| 150   | Skidtubes          | 1 pcs | 8/6/18     | 8/6/18   | 0.00      | 2.07    | Skidtubes-1           |           | MLH            |
| 155   | CNC Bend Skidtubes | 1 pcs | 8/6/18     | 8/6/18   | 0.00      | 1.20    | CNC Bend Skidtube     |           | MLH            |
| 165   | QC                 | 1 pcs | 8/6/18     | 8/6/18   | 0.00      | 0.00    | QC5                   |           | MLH            |
| 180   | Skidtubes          | 1 pcs | 8/6/18     | 8/6/18   | 0.00      | 2.07    | Skidtubes-1           |           | MLH            |
| 190   | QC                 | 1 pcs | 8/6/18     | 8/6/18   | 0.00      | 0.00    | QC5                   |           | BE             |
| 200   | CNC Bend Skidtubes | 1 pcs | 8/6/18     | 8/6/18   | 0.00      | 1.20    | CNC Bend Skidtube     |           | MLH            |
| 210   | Skidtubes          | 1 pcs | 8/6/18     | 8/6/18   | 0.00      | 1.41    | Skidtubes-1           |           | MLH            |
| 220   | QC                 | 1 pcs | 8/6/18     | 8/6/18   | 0.00      | 0.00    | QC5                   |           | BE             |
| 224   | Skidtubes          | 1 pcs | 8/6/18     | 8/6/18   | 0.00      | 3.70    | Skidtubes-1           |           | BE MLH         |
| 225   | QC                 | 1 pcs | 8/6/18     | 8/6/18   | 0.00      | 0.00    | QC5                   |           | PD 18-05-03    |
| 226   | QC                 | 1 pcs | 8/6/18     | 8/6/18   | 0.00      | 0.00    | QC10                  |           | PD 18-05-03    |
| 227   | HandFinish         | 1 pcs | 8/6/18     | 8/6/18   | 0.00      | 1.05    | HandFinish2           |           | BE 18-08-04    |
| 240   | SprayPaint         | 1 pcs | 8/6/18     | 8/6/18   | 0.00      | 0.56    | Spray Paint           |           | KT 18-06-14    |
| 242   | Outsource          | 1 pcs | 8/6/18     | 8/6/18   |           |         | ATE003-VC             | 5         |                |
| 245   | QC                 | 1 pcs | 8/6/18     | 8/6/18   | 0.00      | 0.00    | QC14                  |           | SA 18-08-08    |
| 250   | HandFinish         | 1 pcs | 8/6/18     | 8/6/18   | 0.00      | 1.05    | HandFinish4           | 005020    | BE 18-08-16    |
| 260   | QC                 | 1 pcs | 8/6/18     | 8/6/18   | 0.00      | 0.00    | QC5                   |           | ML 18-08-11    |
| 270   | HandFinish         | 1 pcs | 8/6/18     | 8/6/18   | 0.00      | 1.49    | HandFinish4           |           | BE 18-08-16    |
| 280   | QC                 | 1 pcs | 8/6/18     | 8/6/18   | 0.00      | 0.00    | QC5                   |           | ML 18-08-11    |
| 285   | HandFinish         | 1 pcs | 8/6/18     | 8/6/18   | 0.00      | 1.05    | HandFinish3           |           | BE 18-08-16    |
| 286   | QC                 | 1 pcs | 8/6/18     | 8/6/18   | 0.00      | 0.00    | QC5                   |           | AUG 17 2018    |
| 288   | DC                 | 1 pcs | 8/6/18     | 8/6/18   | 0.00      | 0.00    | DC                    |           | 21 AUG 21 2018 |
| 290   | Packaging          | 1 pcs | 8/6/18     | 8/6/18   | 0.00      | 0.00    | Packaging3-1          |           | 21 AUG 21 2018 |
| 300   | QC21-FG            | 1 Ea  | 8/6/18     | 8/6/18   | 0.00      | 0.00    | QC21                  |           | 21 9-89        |

Part Op 110 - 1- Inspect Mat'l D2500-1-190 for damage 2- Ensure squareness of ends  
Descriptions: 120 - Chemical Conversion Coat per QSI005 4.1  
130 - QC7-Inspect Chemical Conversion Coat

# WORK ORDER NON-CONFORMANCE / UPDATE



DDA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

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| <b>Work Order:</b> _____<br><b>Part No.</b> _____<br><b>NCR No.</b> _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               |                          | <b>DISPOSITION</b><br>Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/><br>Suspected Unapproved <input type="checkbox"/> |                          | <b>AGAINST DEPARTMENT/PROCESS</b><br>Skid-tube <input type="checkbox"/><br>Machining <input type="checkbox"/><br>Thermofforming <input type="checkbox"/><br>Large Fab <input type="checkbox"/><br>Cross tube <input type="checkbox"/><br>Small Fab <input type="checkbox"/><br>Finishing <input type="checkbox"/><br>Composite <input type="checkbox"/><br>Water Jet <input type="checkbox"/><br>Prod. Eng. Coord. <input type="checkbox"/><br>Rec/Store/Packaging <input type="checkbox"/><br>Supplier <input type="checkbox"/><br>Engineering <input type="checkbox"/><br>Quality <input type="checkbox"/><br>Other <input type="checkbox"/> |                          |             |                          |                    |                          |                 |                          |          |                          |              |                          |         |                          |               |                          |              |                          |                   |                          |               |                          |          |                          |        |                          |              |                          |                 |                          |                   |                          |                    |                          |                  |                          |       |                          |                    |                          |                  |                          |          |                          |                  |                          |                     |                          |            |                          |            |                          |                     |                          |                    |                          |                  |                          |                       |                          |               |                          |                  |                          |                       |                          |        |                          |               |                          |          |                          |  |  |
| <b>Date:</b> _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     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Effective:</b> _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    |                          |             |                          |                    |                          |                 |                          |          |                          |              |                          |         |                          |               |                          |              |                          |                   | 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| <b>Description Work Order Deviation</b>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                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| <div style="display: flex; justify-content: space-between;"> <div> <p><b>Root Cause</b></p> <table border="1"> <tr> <td>Environment</td> <td><input type="checkbox"/></td> <td>No Re-verification</td> <td><input type="checkbox"/></td> <td>Pressure/Forced</td> <td><input type="checkbox"/></td> </tr> <tr> <td>Design</td> <td><input type="checkbox"/></td> <td>Operator</td> <td><input type="checkbox"/></td> <td>Bending</td> <td><input type="checkbox"/></td> </tr> <tr> <td>Doc/Data</td> <td><input type="checkbox"/></td> <td>Offset/Setup</td> <td><input type="checkbox"/></td> <td>Centre Not Concen</td> <td><input type="checkbox"/></td> </tr> <tr> <td>Equip/Tooling</td> <td><input type="checkbox"/></td> <td>Supplier</td> <td><input type="checkbox"/></td> <td>Cracks</td> <td><input type="checkbox"/></td> </tr> <tr> <td>Handling/Pre</td> <td><input type="checkbox"/></td> <td>Training</td> <td><input type="checkbox"/></td> <td>Crimp/Kink/Ripple</td> <td><input type="checkbox"/></td> </tr> <tr> <td>Material</td> <td><input type="checkbox"/></td> <td>Use for Testing</td> <td><input type="checkbox"/></td> <td>Cuffs</td> <td><input type="checkbox"/></td> </tr> <tr> <td>Internal Transport</td> <td><input type="checkbox"/></td> <td>Poor Information</td> <td><input type="checkbox"/></td> <td>Crushing</td> <td><input type="checkbox"/></td> </tr> <tr> <td>Tribal Knowledge</td> <td><input type="checkbox"/></td> <td>Rushing</td> <td><input type="checkbox"/></td> <td>Heat Treat</td> <td><input type="checkbox"/></td> </tr> <tr> <td>LOA</td> <td><input type="checkbox"/></td> <td>Product Improvement</td> <td><input type="checkbox"/></td> <td>Wave/Twist in Tube</td> <td><input type="checkbox"/></td> </tr> <tr> <td>Substation</td> <td><input type="checkbox"/></td> <td>Process Improvement</td> <td><input type="checkbox"/></td> <td>Marks/Chatter</td> <td><input type="checkbox"/></td> </tr> <tr> <td>Past Expiry Date</td> <td><input type="checkbox"/></td> <td>Manufacturing Process</td> <td><input type="checkbox"/></td> <td>OTHER:</td> <td><input type="checkbox"/></td> </tr> <tr> <td>Misidentified</td> <td><input type="checkbox"/></td> <td>Past Due</td> <td><input type="checkbox"/></td> <td></td> <td></td> </tr> </table> </div> <div> <p><b>DART AEROSPACE</b></p> <p>Container No: S089667</p> <p>Part: D119 - 646 - 243</p> <p>Job No: 180168</p> <p>Serial No/Batch: S089667</p> <p>Revision: _____</p> <p>Inspector: _____</p> <p>Exp Date: _____</p> <p>Instructions: _____</p> </div> <div> <p><b>Dart Aerospace Ltd.</b><br/>         1270 Aberdeen Street<br/>         Hawkesbury, ON K64 1K7<br/>         CANADA<br/>         TEL.: 1 813 632-5200<br/>         Email: sales@dartaero.com<br/>         www.dartaerospace.com</p> <p>Date: 07/06/18</p> </div> </div> |                          |                                                                                                                                                                                |                          |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                |                          | Environment | <input type="checkbox"/> | No Re-verification | <input type="checkbox"/> | Pressure/Forced | <input type="checkbox"/> | Design   | <input type="checkbox"/> | Operator     | <input type="checkbox"/> | Bending | <input type="checkbox"/> | Doc/Data      | <input type="checkbox"/> | Offset/Setup | <input type="checkbox"/> | Centre Not Concen | <input type="checkbox"/> | Equip/Tooling | <input type="checkbox"/> | Supplier | <input type="checkbox"/> | Cracks | <input type="checkbox"/> | Handling/Pre | <input type="checkbox"/> | Training        | <input type="checkbox"/> | Crimp/Kink/Ripple | <input type="checkbox"/> | Material           | <input type="checkbox"/> | Use for Testing  | <input type="checkbox"/> | Cuffs | <input type="checkbox"/> | Internal Transport | <input type="checkbox"/> | Poor Information | <input type="checkbox"/> | Crushing | <input type="checkbox"/> | Tribal Knowledge | <input type="checkbox"/> | Rushing             | <input type="checkbox"/> | Heat Treat | <input type="checkbox"/> | LOA        | <input type="checkbox"/> | Product Improvement | <input type="checkbox"/> | Wave/Twist in Tube | <input type="checkbox"/> | Substation       | <input type="checkbox"/> | Process Improvement   | <input type="checkbox"/> | Marks/Chatter | <input type="checkbox"/> | Past Expiry Date | <input type="checkbox"/> | Manufacturing Process | <input type="checkbox"/> | OTHER: | <input type="checkbox"/> | Misidentified | <input type="checkbox"/> | Past Due | <input type="checkbox"/> |  |  |
| Environment                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            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Pressure/Forced                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                | <input type="checkbox"/> |             |                          |                    |                          |                 |                          |          |                          |              |                          |         |                          |               |                          |              |                          |              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| Design                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 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| Doc/Data                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               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| Equip/Tooling                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          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| Handling/Pre                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           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Crimp/Kink/Ripple                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              | <input type="checkbox"/> |             |                          |                    |                          |                 |                          |          |                          |              |                          |         |                          |               |                          |              |                          |              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| Material                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               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| Internal Transport                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     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Crushing                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       | <input type="checkbox"/> |             |                          |                    |                          |                 |                          |          |                          |              |                          |         |                          |               |                          |              |                          |              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| Tribal Knowledge                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       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Treat                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     | <input type="checkbox"/> |             |                          |                    |                          |                 |                          |          |                          |              |                          |         |                          |               |                          |              |                          |                   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Wave/Twist in Tube                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             | <input type="checkbox"/> |             |                          |                    |                          |                 |                          |          |                          |              |                          |         |                          |               |                          |              |                          |              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| Substation                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             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Marks/Chatter                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  | <input type="checkbox"/> |             |                          |                    |                          |                 |                          |          |                          |              |                          |         |                          |               |                          |              |                          |              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| Past Expiry Date                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       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| Misidentified                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          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| <div style="display: flex; justify-content: space-between;"> <div> <p><b>Environment</b></p> <table border="1"> <tr> <td>Design</td> <td><input type="checkbox"/></td> <td>Operator</td> <td><input type="checkbox"/></td> <td>Pressure/Forced</td> <td><input type="checkbox"/></td> </tr> <tr> <td>Doc/Data</td> <td><input type="checkbox"/></td> <td>Offset/Setup</td> <td><input type="checkbox"/></td> <td>Bending</td> <td><input type="checkbox"/></td> </tr> <tr> <td>Equip/Tooling</td> <td><input type="checkbox"/></td> <td>Supplier</td> <td><input type="checkbox"/></td> <td>Centre Not Concen</td> <td><input type="checkbox"/></td> </tr> <tr> <td>Handling/Pre</td> <td><input type="checkbox"/></td> <td>Training</td> <td><input type="checkbox"/></td> <td>Cracks</td> <td><input type="checkbox"/></td> </tr> <tr> <td>Material</td> <td><input type="checkbox"/></td> <td>Use for Testing</td> <td><input type="checkbox"/></td> <td>Crimp/Kink/Ripple</td> <td><input type="checkbox"/></td> </tr> <tr> <td>Internal Transport</td> <td><input type="checkbox"/></td> <td>Poor Information</td> <td><input type="checkbox"/></td> <td>Cuffs</td> <td><input type="checkbox"/></td> </tr> <tr> <td>Tribal Knowledge</td> <td><input type="checkbox"/></td> <td>Rushing</td> <td><input type="checkbox"/></td> <td>Crushing</td> <td><input type="checkbox"/></td> </tr> <tr> <td>LOA</td> <td><input type="checkbox"/></td> <td>Product Improvement</td> <td><input type="checkbox"/></td> <td>Heat Treat</td> <td><input type="checkbox"/></td> </tr> <tr> <td>Substation</td> <td><input type="checkbox"/></td> <td>Process Improvement</td> <td><input type="checkbox"/></td> <td>Wave/Twist in Tube</td> <td><input type="checkbox"/></td> </tr> <tr> <td>Past Expiry Date</td> <td><input type="checkbox"/></td> <td>Manufacturing Process</td> <td><input type="checkbox"/></td> <td>Marks/Chatter</td> <td><input type="checkbox"/></td> </tr> <tr> <td>Misidentified</td> <td><input type="checkbox"/></td> <td>Past Due</td> <td><input type="checkbox"/></td> <td>OTHER:</td> <td><input type="checkbox"/></td> </tr> </table> </div> <div> <p><b>DART AEROSPACE</b></p> <p>Container No: S089667</p> <p>Part: D119 - 646 - 243</p> <p>Job No: 180168</p> <p>Serial No/Batch: S089667</p> <p>Revision: _____</p> <p>Inspector: _____</p> <p>Exp Date: _____</p> <p>Instructions: _____</p> </div> <div> <p><b>Dart Aerospace Ltd.</b><br/>         1270 Aberdeen Street<br/>         Hawkesbury, ON K64 1K7<br/>         CANADA<br/>         TEL.: 1 813 632-5200<br/>         Email: sales@dartaero.com<br/>         www.dartaerospace.com</p> <p>Date: 07/06/18</p> </div> </div>                                                                                                                                                    |                          |                                                                                                                                                                                |                          |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                |                          | Design      | <input type="checkbox"/> | Operator           | <input type="checkbox"/> | Pressure/Forced | <input type="checkbox"/> | Doc/Data | <input type="checkbox"/> | Offset/Setup | <input type="checkbox"/> | Bending | <input type="checkbox"/> | Equip/Tooling | <input type="checkbox"/> | Supplier     | <input type="checkbox"/> | Centre Not Concen | <input type="checkbox"/> | Handling/Pre  | <input type="checkbox"/> | Training | <input type="checkbox"/> | Cracks | <input type="checkbox"/> | Material     | <input type="checkbox"/> | Use for Testing | <input type="checkbox"/> | Crimp/Kink/Ripple | <input type="checkbox"/> | Internal Transport | <input type="checkbox"/> | Poor Information | <input type="checkbox"/> | Cuffs | <input type="checkbox"/> | Tribal Knowledge   | <input type="checkbox"/> | Rushing          | <input type="checkbox"/> | Crushing | <input type="checkbox"/> | LOA              | <input type="checkbox"/> | Product Improvement | <input type="checkbox"/> | Heat Treat | <input type="checkbox"/> | Substation | <input type="checkbox"/> | Process Improvement | <input type="checkbox"/> | Wave/Twist in Tube | <input type="checkbox"/> | Past Expiry Date | <input type="checkbox"/> | Manufacturing Process | <input type="checkbox"/> | Marks/Chatter | <input type="checkbox"/> | Misidentified    | <input type="checkbox"/> | Past Due              | <input type="checkbox"/> | OTHER: | <input type="checkbox"/> |               |                          |          |                          |  |  |
| Design                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 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| Doc/Data                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               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| Equip/Tooling                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          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| Handling/Pre                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           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| Material                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               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Crimp/Kink/Ripple                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              | <input type="checkbox"/> |             |                          |                    |                          |                 |                          |          |                          |              |                          |         |                          |               |                          |              |                          |              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| Internal Transport                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     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| Tribal Knowledge                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       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| Substation                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             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Wave/Twist in Tube                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             | <input type="checkbox"/> |             |                          |                    |                          |                 |                          |          |                          |              |                          |         |                          |               |                          |              |                          |              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| Past Expiry Date                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       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| Misidentified                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          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| <div style="display: flex; justify-content: space-between;"> <div> <p><b>Environment</b></p> <table border="1"> <tr> <td>Design</td> <td><input type="checkbox"/></td> <td>Operator</td> <td><input type="checkbox"/></td> <td>Pressure/Forced</td> <td><input type="checkbox"/></td> </tr> <tr> <td>Doc/Data</td> <td><input type="checkbox"/></td> <td>Offset/Setup</td> <td><input type="checkbox"/></td> <td>Bending</td> <td><input type="checkbox"/></td> </tr> <tr> <td>Equip/Tooling</td> <td><input type="checkbox"/></td> <td>Supplier</td> <td><input type="checkbox"/></td> <td>Centre Not Concen</td> <td><input type="checkbox"/></td> </tr> <tr> <td>Handling/Pre</td> <td><input type="checkbox"/></td> <td>Training</td> <td><input type="checkbox"/></td> <td>Cracks</td> <td><input type="checkbox"/></td> </tr> <tr> <td>Material</td> <td><input type="checkbox"/></td> <td>Use for Testing</td> <td><input type="checkbox"/></td> <td>Crimp/Kink/Ripple</td> <td><input type="checkbox"/></td> </tr> <tr> <td>Internal Transport</td> <td><input type="checkbox"/></td> <td>Poor Information</td> <td><input type="checkbox"/></td> <td>Cuffs</td> <td><input type="checkbox"/></td> </tr> <tr> <td>Tribal Knowledge</td> <td><input type="checkbox"/></td> <td>Rushing</td> <td><input type="checkbox"/></td> <td>Crushing</td> <td><input type="checkbox"/></td> </tr> <tr> <td>LOA</td> <td><input type="checkbox"/></td> <td>Product Improvement</td> <td><input type="checkbox"/></td> <td>Heat Treat</td> <td><input type="checkbox"/></td> </tr> <tr> <td>Substation</td> <td><input type="checkbox"/></td> <td>Process Improvement</td> <td><input type="checkbox"/></td> <td>Wave/Twist in Tube</td> <td><input type="checkbox"/></td> </tr> <tr> <td>Past Expiry Date</td> <td><input type="checkbox"/></td> <td>Manufacturing Process</td> <td><input type="checkbox"/></td> <td>Marks/Chatter</td> <td><input type="checkbox"/></td> </tr> <tr> <td>Misidentified</td> <td><input type="checkbox"/></td> <td>Past Due</td> <td><input type="checkbox"/></td> <td>OTHER:</td> <td><input type="checkbox"/></td> </tr> </table> </div> <div> <p><b>DART AEROSPACE</b></p> <p>Container No: S089667</p> <p>Part: D119 - 646 - 243</p> <p>Job No: 180168</p> <p>Serial No/Batch: S089667</p> <p>Revision: _____</p> <p>Inspector: _____</p> <p>Exp Date: _____</p> <p>Instructions: _____</p> </div> <div> <p><b>Dart Aerospace Ltd.</b><br/>         1270 Aberdeen Street<br/>         Hawkesbury, ON K64 1K7<br/>         CANADA<br/>         TEL.: 1 813 632-5200<br/>         Email: sales@dartaero.com<br/>         www.dartaerospace.com</p> <p>Date: 07/06/18</p> </div> </div>                                                                                                                                                    |                          |                                                                                                                                                                                |                          |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                |                          | Design      | <input type="checkbox"/> | Operator           | <input type="checkbox"/> | Pressure/Forced | <input type="checkbox"/> | Doc/Data | <input type="checkbox"/> | Offset/Setup | <input type="checkbox"/> | Bending | <input type="checkbox"/> | Equip/Tooling | <input type="checkbox"/> | Supplier     | <input type="checkbox"/> | Centre Not Concen | <input type="checkbox"/> | Handling/Pre  | <input type="checkbox"/> | Training | <input type="checkbox"/> | Cracks | <input type="checkbox"/> | Material     | <input type="checkbox"/> | Use for Testing | <input type="checkbox"/> | Crimp/Kink/Ripple | <input type="checkbox"/> | Internal Transport | <input type="checkbox"/> | Poor Information | <input type="checkbox"/> | Cuffs | <input type="checkbox"/> | Tribal Knowledge   | <input type="checkbox"/> | Rushing          | <input type="checkbox"/> | Crushing | <input type="checkbox"/> | LOA              | <input type="checkbox"/> | Product Improvement | <input type="checkbox"/> | Heat Treat | <input type="checkbox"/> | Substation | <input type="checkbox"/> | Process Improvement | <input type="checkbox"/> | Wave/Twist in Tube | <input type="checkbox"/> | Past Expiry Date | <input type="checkbox"/> | Manufacturing Process | <input type="checkbox"/> | Marks/Chatter | <input type="checkbox"/> | Misidentified    | <input type="checkbox"/> | Past Due              | <input type="checkbox"/> | OTHER: | <input type="checkbox"/> |               |                          |          |                          |  |  |
| Design                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 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Pressure/Forced                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                | <input type="checkbox"/> |             |                          |                    |                          |                 |                          |          |                          |              |                          |         |                          |               |                          |              |                          |              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| Doc/Data                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               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                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       | <input type="checkbox"/> |             |                          |                    |                          |                 |                          |          |                          |              |                          |         |                          |               |                          |              |                          |                   |  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| Equip/Tooling                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          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Not Concen                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              | <input type="checkbox"/> |             |                          |                    |                          |                 |                          |          |                          |              |                          |         |                          |               |                          |              |                          |                   | 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| Handling/Pre                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            | <input type="checkbox"/> | Training                                                                                                                                                                       | <input type="checkbox"/> | Cracks                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         | <input type="checkbox"/> |             |                          |                    |                          |                 |                          |          |                          |              |                          |         |                          |               |                          |              |                          |                   |  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| Material                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                | <input type="checkbox"/> | Use for Testing                                                                                                                                                                | <input type="checkbox"/> | Crimp/Kink/Ripple                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              | <input type="checkbox"/> |             |                          |                    |                          |                 |                          |          |                          |              |                          |         |                          |               |                          |              |                          |              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| Internal Transport                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      | <input type="checkbox"/> | Poor Information                                                                                                                                                               | <input type="checkbox"/> | Cuffs                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          | <input type="checkbox"/> |             |                          |                    |                          |                 |                          |          |                          |              |                          |         |                          |               |                          |              |                          |                   |  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| Tribal Knowledge                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       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Crushing                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       | <input type="checkbox"/> |             |                          |                    |                          |                 |                          |          |                          |              |                          |         |                          |               |                          |              |                          |              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| LOA                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    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Treat                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     | <input type="checkbox"/> |             |                          |                    |                          |                 |                          |          |                          |              |                          |         |                          |               |                          |              |                          |                   |                          |               |                          |          |                          |        |                          |              |                          |                 |                          |                   |                          |                    |                          |                  |                          |       |                          |                    |                          |                  |                          |          |                          |                  |                          |                     |                          |            |                          |            |                          |                     |                          |                    |                          |                  |                          |                       |                          |               |                          |                  |                          |   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| Substation                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             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Wave/Twist in Tube                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             | <input type="checkbox"/> |             |                          |                    |                          |                 |                          |          |                          |              |                          |         |                          |               |                          |              |                          |              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| Past Expiry Date                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       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Marks/Chatter                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  | <input type="checkbox"/> |             |                          |                    |                          |                 |                          |          |                          |              |                          |         |                          |               |                          |              |                          |              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| Misidentified                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          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                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       | <input type="checkbox"/> |             |                          |                    |                          |                 |                          |          |                          |              |                          |         |                          |               |                          |              |                          |                   |  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                 |                          |        |                          |               |                          |          |                          |  |  |



150 - 1- Install drill jig DT9480 drill all x-bolt spacer holes using 3/16 drill first side only. 2- 2nd side, locating from first saddle holes use DT9861 A/B to drill 2nd side fwd saddle holes. 3- 2nd side locating from fwd saddle drill remaining crossbolt spacer holes using DT9477 4- Scribe batch # inside aft end of tube

155 - 1- Bend AFT end of tube using CNC Bender 1 and bend prog. D3905 AFT as per dwg D3905. Must use bending Aid DT9538, located 23.25" from Aft end. 2- Ensure bending Aid DT9538 is positioned correctly, that the bender set up in on full wide and that the indexing ridge is covered with graphite grease.

165 - QC5- Inspect part completeness to step on W/O

180 - 1- Verify dimension of bend as per dwg D3905 2- Buff out marks left from bending. 3- Drill Aft Float bag holes using DT9493 as per dwg D3905 detail G and section F-F, open to finished size 4- Open x-bolt spacer holes to finished size as per dwg (sections D-D and E-E) \*\*\*DO NOT OPEN FWD SADDLE HOLES\*\*\* 5- Drill Aft wearplate and wearpad holes using DT9546 and DT9545 as per dwg D3905 detail G open to finished size 6- Deburr, blow out chips from inside of tube 7- Bond web in place as per Dwg D3905 & QSI 015. A/R Sikaflex-291 11/38874 Sikaflex expire date: 19-03-06 Start: \_\_\_\_\_ Time: \_\_\_\_\_ Finish: \_\_\_\_\_ Time: \_\_\_\_\_ \*\*\*\*\* (Adhere for 12 hours)\*\*\*\*\*

190 - QC5- Inspect part completeness to step on W/O

200 - 1- Bend Fwd end of tube using bender 1 and bend prog. D3905 & Folio -04 Fwd. Use bending aid DT9544 ensure proper positioning 2- Cut Fwd end of tube as per dwg. \*\*\*VERIFY MEASUREMENT BEFORE CUTTING\*\*\*

210 - 1- Buff out marks left from bending 2- Drill Fwd cap holes using DT8215. 3- Open Fwd saddle holes to finished size as per dwg 4- Drill Fwd x-bolt hole and open to finished size using DT9816 5- Drill 1.87" and 3.74 holes using DT10045 A&B locate from FWD saddle hole. (verify measurement) as per dwg. 6- Drill towing hole using DT10047 locate from FWD saddle hole and open to finished size. 7- C'sink FWD cap hole as per detail "C" 10- Deburr, blow out chips from inside of tube.

220 - QC5- Inspect part completeness to step on W/O

224 - NOTE: TACK IN 2 MOST FWD X-BOLT SPACERS AND TEST FIT FWD GROUND HANDLING FIXTURE, IF FIXTURE FITS WELL THEN PROCEED. FIXTURE DT10091. 1- Countersink x-bolt holes as per dwg 2- Remove alodine prepare for welding 3- Insert x-bolt spacers 4- Weld x-bolt spacer as per dwg A/R Alum rod Batch: 138824 5- Grind welds flush as per dwg 6- Counter bore x-bolt holes as per dwg 7- Deburr 8- Pick D2855-5 cap and transfer drill missing hole. Deburr and identify cap with skidtube batch#.

225 - QC5- Inspect part completeness to step on W/O TEST FIT USING FIXTURE DT10091.

226 - QC10- Inspect visual per QSI004- ground welds

227 - Pressure Wash per QSI005 4.3

240 - Spray Painting per QSI005 4.2 \*\*\*\*\*AS PER DEO DETAIL "F" NOTE 8, SHEET 8 MASK THIS AREA, DO NOT APPLY PRIMER OR PAINT\*\*\*\*\* PRIME AS PER DWG AND QSI 005 4.2 BATCH: 138862 PAINT WHITE AS PER DWG AND QSI 005 4.2 BATCH: 138910

245 - QC14- Inspect Spray Paint

250 - Assemble as per dwg 1-Install inserts as per Dwg D3905.

260 - QC5- Inspect part completeness to step on W/O

270 - 1-Install wearpads, gaskets and wearplates as per Dwg D3905. Put sikaflex in insert before installing bolts and washers A/R Sikaflex-240/-291 1138874 Sikaflex expire date: 06/19 2- install plugs assembly as per dwg. 3- Inspect for foreign objects as per QSI 024 4- Install D2855-3 Cap and seal with Sikaflex. Clean excess adhesive. A/R Sikaflex-240/-291 1138874 Sikaflex expire date: 06/19 5- Install insert in D2855- Cap. Install cap and seal with Sikaflex. Clean excess adhesive. A/R Sikaflex-240/-291 1138874 Sikaflex expire date: 06/19 6- Install (2) D5101-041 and (1) D5101-047 as per dwg by using DT10117

280 - QC5- Inspect part completeness to step on W/O

285 - Wing Walk as per dwg QSI005 4.4 Batch: 5098120

286 - QC5- Inspect part completeness to step on W/O

288 - Document Control Photocopy bluefile & type labels per PPP D119-646-243 CHG 005

290 - Identify as per dwg & Stock Location: \_\_\_\_\_

300 - QC21- Final Inspection - Work Order Release

205028

### Job BOM

| Part / Item   | Component Name         | Quantity      | Operation             | Container |
|---------------|------------------------|---------------|-----------------------|-----------|
| D2500-1-190   | Ext'n -I' Beam Tube 4" | 1 Ea (1 ea)   | 90-Start up Operation |           |
| D3681-1       | Spacer                 | 8 Ea (8 ea)   | 90-Start up Operation | 5084724   |
| D3903-1       | Spacer                 | 12 Ea (12 ea) | 90-Start up Operation | 5084655   |
| D3885-3       | Float Web              | 1 Ea (1 ea)   | 180-Skidtubes         | 5096470   |
| D2579         | Crossbolt Spacer       | 2 Ea (2 ea)   | 224-Skidtubes         | 5051552   |
| D2855-5       | Cap                    | 1 Ea (1 ea)   | 224-Skidtubes         | 5066894   |
| ALS4-1032-130 | Rivnut                 | 10 Ea (10 ea) | 250-HandFinish        | 5007279   |
| ALS4-1032-225 | Rivnut                 | 1 Ea (1 ea)   | 270-HandFinish        | 5058138   |
| AN3C46A       | Bolt                   | 4 Ea (4 ea)   | 270-HandFinish        | 5095398   |
| AN3C50A       | Bolt                   | 4 Ea (4 ea)   | 270-HandFinish        | 5079135   |
| AN3C5A        | Bolt                   | 12 Ea (12 ea) | 270-HandFinish        | AS095214  |
| AN4C46A       | Bolt                   | 3 Ea (3 ea)   | 270-HandFinish        | 5093600   |
| D2855-3       | Cap                    | 1 Ea (1 ea)   | 270-HandFinish        | 5066002   |
| D3411-3       | Washer                 | 16 Ea (16 ea) | 270-HandFinish        | 5099749   |
| D3672-1       | Washer, Phenolic       | 2 Ea (2 ea)   | 270-HandFinish        | F150074   |
| D3847-1       | Wearpad                | 1 Ea (1 ea)   | 270-HandFinish        | 5084440   |
| D3847-11      | Wearpad                | 1 Ea (1 ea)   | 270-HandFinish        | 5026852   |

|               |                                                   |               |                |                 |
|---------------|---------------------------------------------------|---------------|----------------|-----------------|
| D3849-045     | Run-on Landing Wearplate Aft For Float Skid tubes | 1 Ea (1 ea)   | 270-HandFinish | S089093         |
| D3849-047     | Run-on Landing Wearplate Fwd For Float Skid tubes | 1 Ea (1 ea)   | 270-HandFinish | F154850         |
| D3904-1       | Washer                                            | 16 Ea (16 ea) | 270-HandFinish | S091775         |
| D5101-041     | Crossbolt Spacer Assembly                         | 2 Ea (2 ea)   | 270-HandFinish | F159549         |
| D5101-047     | Crossbolt Spacer Assembly                         | 1 Ea (1 ea)   | 270-HandFinish | S072225         |
| D5101-3       | Insert                                            | 6 Ea (6 ea)   | 270-HandFinish | F158939         |
| D5101-5       | Insert                                            | 6 Ea (6 ea)   | 270-HandFinish | F158796         |
| MS21043-3     | Nut                                               | 8 Ea (8 ea)   | 270-HandFinish | S027748 S062620 |
| MS21043-4     | Nut                                               | 3 Ea (3 ea)   | 270-HandFinish | S038963 S08927  |
| MS24694-C52   | Screw                                             | 2 Ea (2 ea)   | 270-HandFinish | S067269-1       |
| NAS1149C0332R | Washer                                            | 8 Ea (8 ea)   | 270-HandFinish | S071663         |
| NAS1149D0416J | Washer                                            | 3 Ea (3 ea)   | 270-HandFinish | FM131511        |

### Job Allocations

| Operation             | Component Part | Required | Inventory | Allocated |
|-----------------------|----------------|----------|-----------|-----------|
| 90-Start up Operation | D2500-1-190    | 1        | 37        | 0         |
|                       | D3681-1        | 8        | 219       | 0         |
|                       | D3903-1        | 12       | 190       | 0         |
| 180-Skid tubes        | D3885-3        | 1        | 2         | 0         |
| 224-Skid tubes        | D2579          | 2        | 175       | 0         |
|                       | D2855-5        | 1        | 81        | 0         |
| 250-HandFinish        | ALS4-1032-130  | 10       | 13,354    | 0         |
| 270-HandFinish        | ALS4-1032-225  | 1        | 4,225     | 0         |
|                       | AN3C46A        | 4        | 122       | 0         |
|                       | AN3C50A        | 4        | 159       | 0         |
|                       | AN3C5A         | 12       | 2,030     | 0         |
|                       | AN4C46A        | 3        | 83        | 0         |
|                       | D2855-3        | 1        | 26        | 0         |
|                       | D3411-3        | 16       | 24        | 0         |
|                       | D3672-1        | 2        | 1,076     | 0         |
|                       | D3847-1        | 1        | 80        | 0         |
|                       | D3847-11       | 1        | 21        | 0         |
|                       | D3849-045      | 1        | 0         | 0         |
|                       | D3849-047      | 1        | 3         | 0         |
|                       | D3904-1        | 16       | 90        | 0         |
|                       | D5101-041      | 2        | 14        | 0         |
|                       | D5101-047      | 1        | 5         | 0         |
|                       | D5101-3        | 6        | 56        | 0         |
|                       | D5101-5        | 6        | 42        | 0         |
|                       | MS21043-3      | 8        | 1,125     | 0         |
|                       | MS21043-4      | 3        | 401       | 0         |
|                       | MS24694-C52    | 2        | 187       | 0         |
|                       | NAS1149C0332R  | 8        | 5,075     | 0         |
|                       | NAS1149D0416J  | 3        | 2,986     | 0         |

### Part Specifications

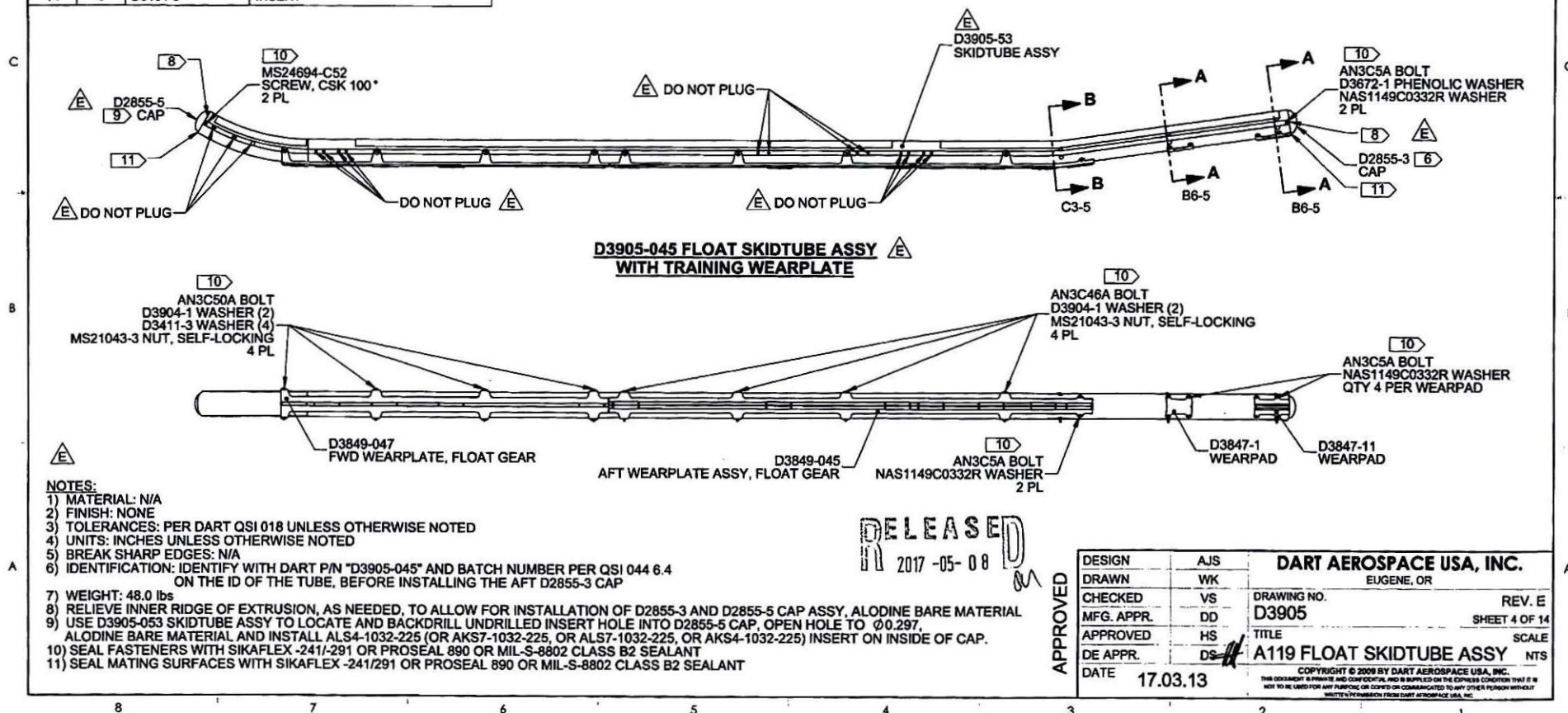
Specifications could not be found.



| ITEM | QTY | P/N       | DESCRIPTION                    |
|------|-----|-----------|--------------------------------|
|      | X   | D3905-045 | FLOAT SKIDTUBE ASSY            |
| 1    | 1   | D2855-3   | CAP                            |
| 2    | 1   | D2855-5   | CAP                            |
| 3    | 16  | D3411-3   | WASHER                         |
| 4    | 2   | D3672-1   | PHENOLIC WASHER                |
| 5    | 1   | D3847-1   | WEARPAD                        |
| 6    | 1   | D3847-11  | WEARPAD                        |
| 7    | 1   | D3849-045 | AFT WEARPLATE ASSY, FLOAT GEAR |
| 8    | 1   | D3849-047 | FWD WEARPLATE, FLOAT GEAR      |
| 9    | 16  | D3904-1   | WASHER                         |
| 10   | 1   | D3905-053 | SKIDTUBE SUB ASSEMBLY          |
| 11   | 2   | D5101-041 | CROSSBOLT SPACER ASSY          |
| 12   | 1   | D5101-047 | CROSS BOLT SPACER              |
| 13   | 6   | D5101-3   | INSERT                         |
| 14   | 6   | D5101-5   | INSERT                         |

| ITEM | QTY | P/N           | DESCRIPTION       |
|------|-----|---------------|-------------------|
| 15   | 1   | ALS4-1032-225 | INSERT            |
| 16   | 12  | AN3C5A        | BOLT              |
| 17   | 4   | AN3C46A       | BOLT              |
| 18   | 4   | AN3C50A       | BOLT              |
| 19   | 3   | AN4C46A       | BOLT              |
| 20   | 8   | MS21043-3     | NUT, SELF-LOCKING |
| 21   | 3   | MS21043-4     | NUT, SELF-LOCKING |
| 22   | 2   | MS24694-C52   | SCREW, CSK 100°   |
| 15   | 12  | NAS1149C0332R | WASHER            |
| 24   | 6   | NAS1149D0416J | WASHER            |

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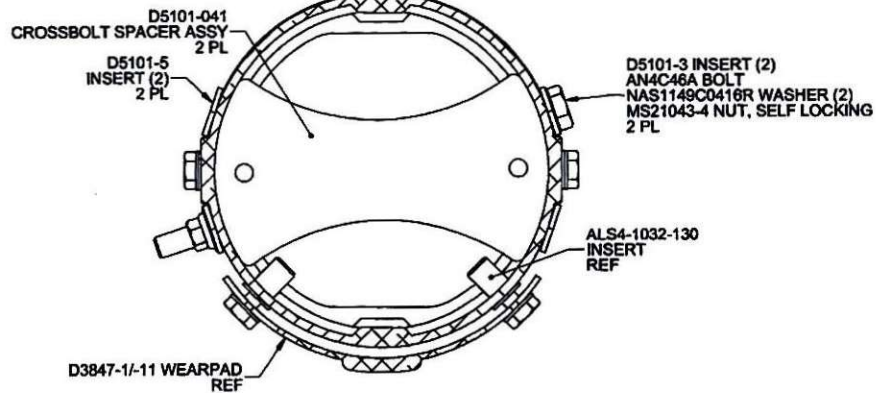
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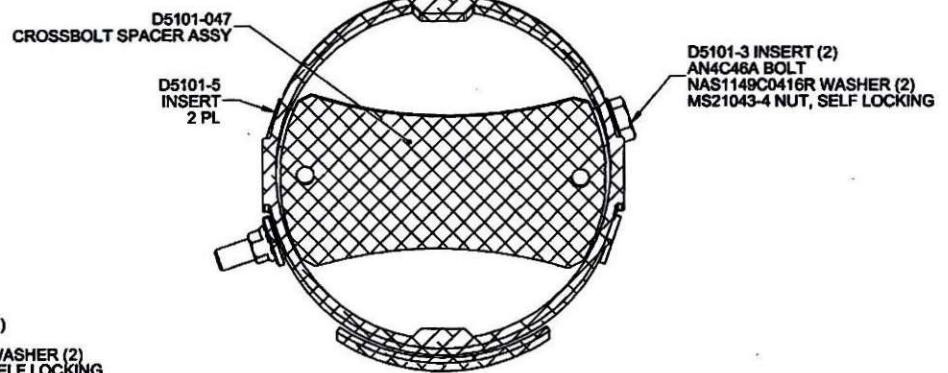
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A



**SECTION A-A**  
SCALE: 12X



**SECTION B-B**  
SCALE 12X

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2017-05-08

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|            |          |                                                                                                                                                                                                                                                                                                                 |               |
|------------|----------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------|
| DESIGN     | AJS      | <b>DART AEROSPACE USA, INC.</b>                                                                                                                                                                                                                                                                                 |               |
| DRAWN      | WK       | EUGENE, OR                                                                                                                                                                                                                                                                                                      |               |
| CHECKED    | VS       | DRAWING NO.                                                                                                                                                                                                                                                                                                     | REV. E        |
| MFG. APPR. | DD       | D3905                                                                                                                                                                                                                                                                                                           | SHEET 5 OF 14 |
| APPROVED   | HS       | TITLE                                                                                                                                                                                                                                                                                                           | SCALE         |
| DE APPR.   | D8       | A119 FLOAT SKIDTUBE ASSY                                                                                                                                                                                                                                                                                        | NTS           |
| DATE       | 17.03.13 | <small>CONFIDENTIAL © 2008 BY DART AEROSPACE USA, INC.<br/>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS<br/>NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT<br/>WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small> |               |

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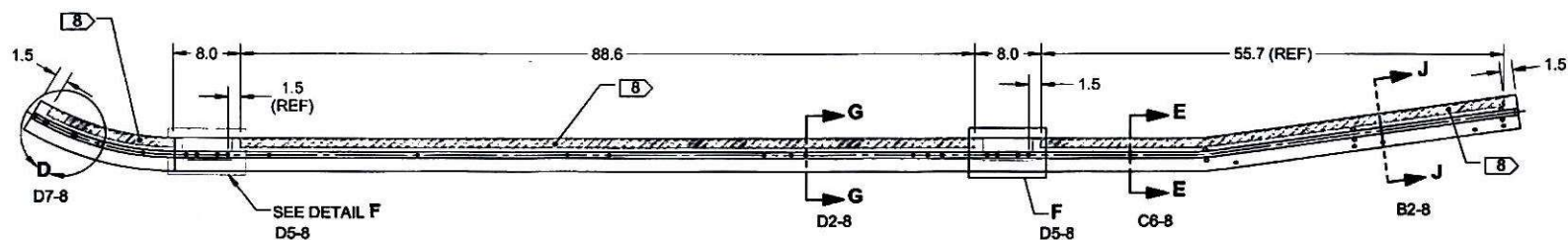
4

3

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1

| ITEM | QTY | P/N           | DESCRIPTION           |
|------|-----|---------------|-----------------------|
|      | X   | D3905-053     | SKIDTUBE SUB ASSY     |
| 1    | 2   | D2579         | CROSS BOLT SPACER     |
| 2    | 8   | D3681-1       | SPACER                |
| 3    | 12  | D3903-1       | SPACER                |
| 4    | 1   | D3905-063     | SKIDTUBE SUB ASSEMBLY |
| 5    | 10  | ALS4-1032-130 | INSERT                |



**D3905-053 SKIDTUBE SUB ASSEMBLY**

**NOTES:**

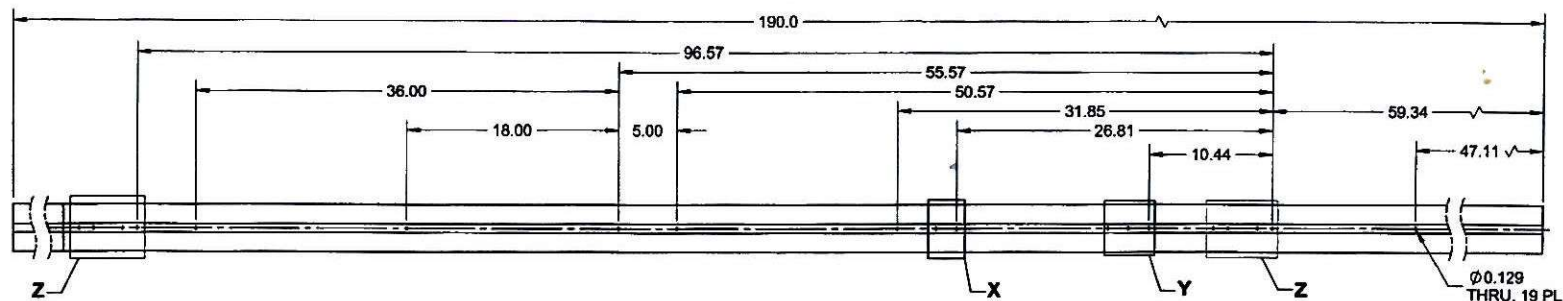
- 1) MATERIAL: N/A
- 2) FINISH: PRIME (REF 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2.2.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY AT NEXT ASSEMBLY
- 7) WEIGHT: N/A
- 8) AFTER APPLICATION OF FINISH, PAINT TOP SURFACE OF SKIDTUBE WITH MIL-W-5044 ANTI-SKID PAINT (WING WALK) AS INDICATED TO 0.50" ABOVE LOCATION RIDGE, PER QSI 005 SECTION 4.4

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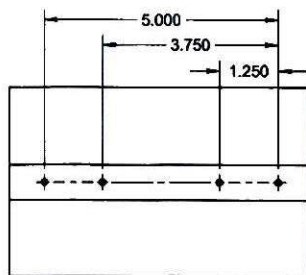
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| DESIGN     | AJS      | <b>DART AEROSPACE USA, INC.</b>                                                                                                                                                                                                                                                     |               |
| DRAWN      | WK       | EUGENE, OR                                                                                                                                                                                                                                                                          |               |
| CHECKED    | VS       | DRAWING NO.                                                                                                                                                                                                                                                                         | REV. E        |
| MFG. APPR. | DD       | D3905                                                                                                                                                                                                                                                                               | SHEET 7 OF 14 |
| APPROVED   | HS       | TITLE                                                                                                                                                                                                                                                                               | SCALE         |
| DE APPR.   | DS       | A119 FLOAT SKIDTUBE ASSY                                                                                                                                                                                                                                                            | NTS           |
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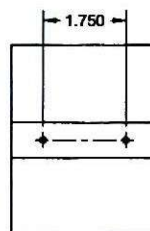




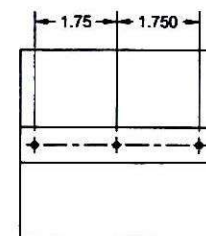
**D3905-3 SKIDTUBE PILOT HOLE DETAIL**



**DETAIL Z**  
SCALE: 4X



**DETAIL X**  
SCALE: 4X



**DETAIL Y**  
SCALE: 4X

**NOTES:**

- 1) MATERIAL: MAKE FROM D2500-1-190 EXTRUSION
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AT FINAL ASSEMBLY
- 7) WEIGHT: N/A

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|            |          |                                                                                                                                                                                                                                                                                                    |                |
|------------|----------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------|
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| DRAWN      | WK       | EUGENE, OR                                                                                                                                                                                                                                                                                         |                |
| CHECKED    | VS       | DRAWING NO.                                                                                                                                                                                                                                                                                        | REV. E         |
| MFG. APPR. | DD       | D3905                                                                                                                                                                                                                                                                                              | SHEET 14 OF 14 |
| APPROVED   | HS       | TITLE                                                                                                                                                                                                                                                                                              | SCALE          |
| DE APPR.   | DS       | A119 FLOAT SKIDTUBE ASSY                                                                                                                                                                                                                                                                           | NTS            |
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